CLEAN COPY OF AMENDED CLAIMS 1, 3, AND 9

1. (Amended) A method of manufacturing a bending-resistant, torsionally yielding tubular profiled member as a transverse support of a twist beam rear axle of a passenger car, the method comprising the steps of:

cold-forming a tube blank of tempering steel to a tubular profiled member with a torsionally yielding central longitudinal section of a U-shaped cross-section and with opposed torsion-proof end sections, wherein the tempering steel of the tube blank is of the specification 22MnB5;

annealing transitional sections of the tubular profiled member located between the torsionally yielding central longitudinal section and the opposed torsion-proof end sections at a temperature level between 920° C and 950° C;

hardening the tubular profiled member in water at a temperature above the AC3 point;

tempering the tubular profiled member at a temperature of approximately 280° C for a duration of approximately 20 minutes;

subjecting the tubular profiled member at least to an outer surface hardening process; and

subjecting the tubular profiled member to further configuration processing steps for completing a twist beam rear axle.

3. (Amended) The method according to claim 1, wherein the step of annealing is carried out at a temperature level of approximately 930° C.

9. (Amended) A method of manufacturing a bending-resistant, torsionally yielding tubular profiled member as a transverse support of a twist beam rear axle of a passenger car, the method comprising the steps of:

cold-forming a tube blank of case hardening steel to a tubular profiled member with a torsionally yielding central longitudinal section of a U-shaped cross-section and opposed torsion-proof end sections, wherein the case-hardening steel of the tube blank is of the specification C15;

case-hardening transitional sections of the tubular profiled member located between the torsionally yielding central longitudinal section and the opposed torsion-proof end sections during a heat treatment with carburization of the surface of the tubular profiled member and subsequent quenching;

subjecting the tubular profiled member at least to an outer surface hardening process; and

subjecting the tubular profiled member to further configuration processing steps for completing a twist beam rear axle.